

Date: Wednesday, 6/28/2006 10:14:29 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARPLATE
<b>Job Number</b>	: 27713		
<b>Estimate Number</b>	: 12464		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D35087
<b>This Issue</b>	: 6/28/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3508 PREL
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: N/A	<b>Drawing Revision</b>	: PREL
	<b>Type</b> : SMALL / MED FAB	<b>Material</b>	: N/A
<b>Written By</b>	: <u>See comment below</u>	<b>Due Date</b>	: 7/5/2006
<b>Checked &amp; Approved By</b>	: <u>06-06-28</u>	<b>Qty:</b>	2
<b>Comment</b>	: Est Rev: New Issue 06-06-20 JLM	<b>Um:</b>	Each

Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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**Comment:** Qty.: 0.3272 sf(s)/Unit Total: 0.6544 sf(s)  
 1010/1025/A21/6aA SHEET  
 (M1010S20GA)  
 Batch: M100473

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3508  
 Dwg Rev: Prel  
 Prog Rev: Prel

2-Deburr if necessary

SAD 06:06:29

②

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:06:29

②

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JLM 06-07-03

②

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 1-Form on brake using DT8178 and DT8261 as per Dwg D3508

SAD 06/07/04

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 26/07/07

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 10:14:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27713

Part Number: D35087

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*June 27, 04* (2)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*FE 06 07 05* (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*g.m 06-07-05*

(2) ~~(2)~~

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: */*

*PC 6/8/06* (2)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/15/07* (2)  
*[Signature]*

Job Completion



*Done*  
*Return to PH*  
*Jul*  
*U 06-07-07*

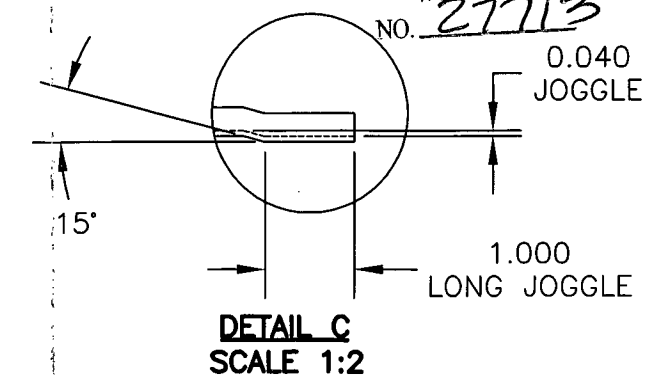
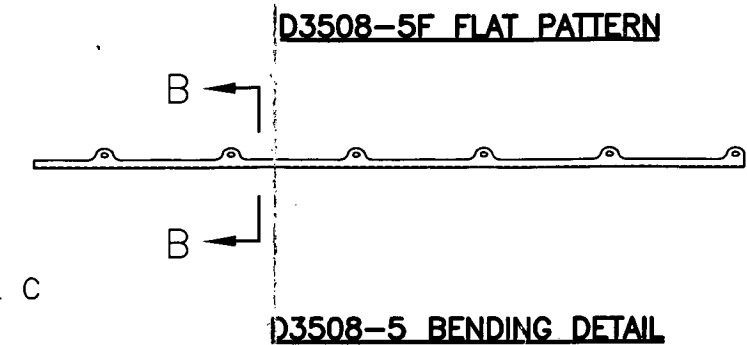
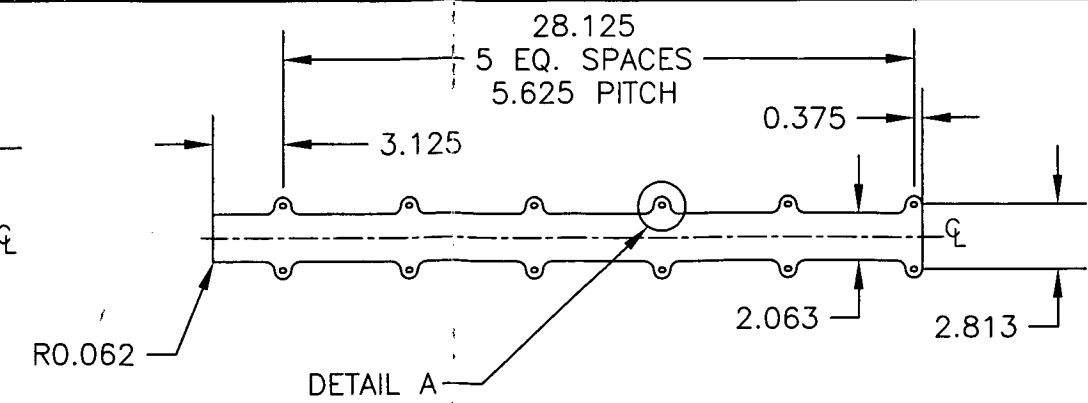
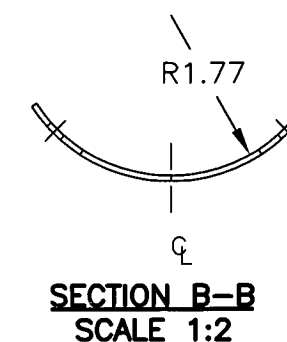
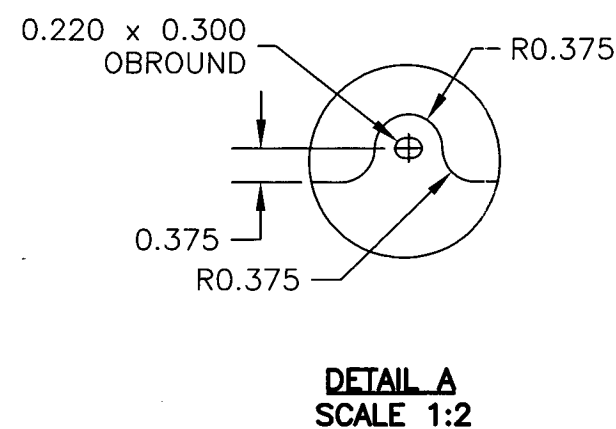
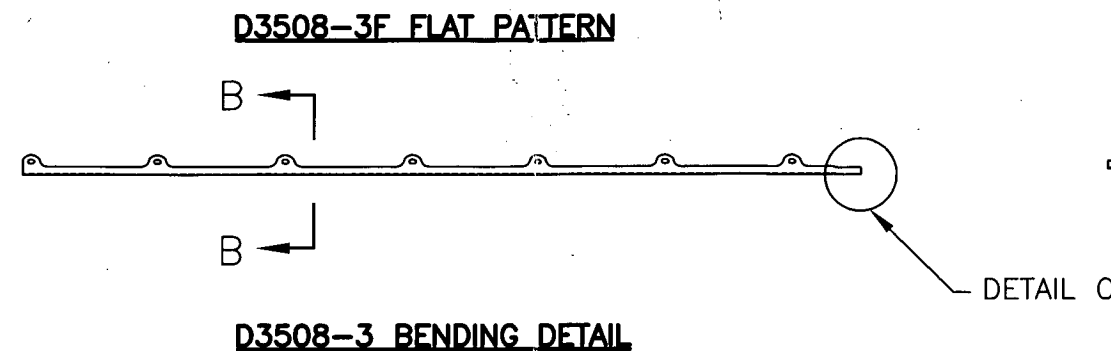
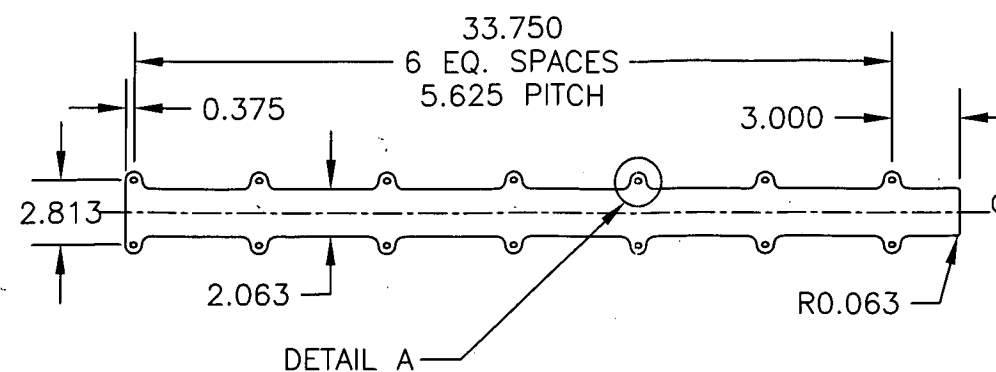
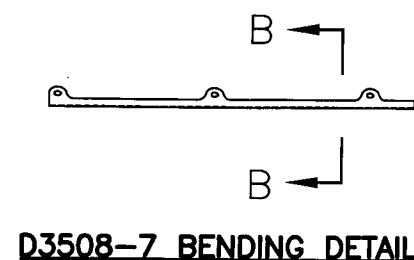
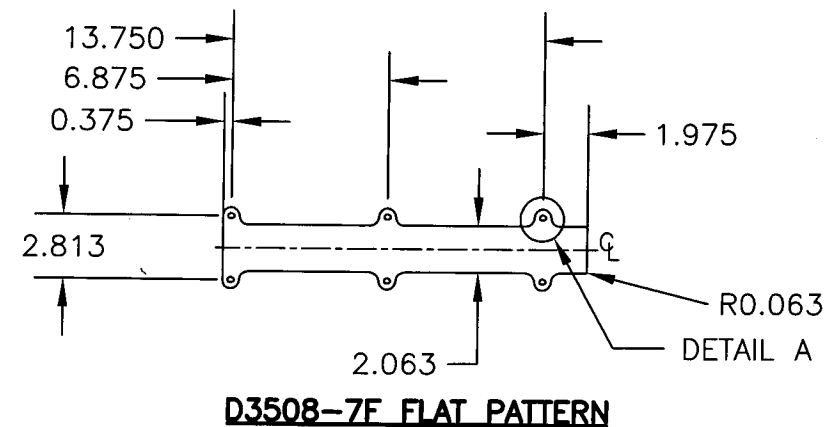
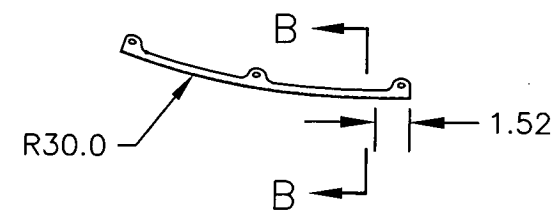
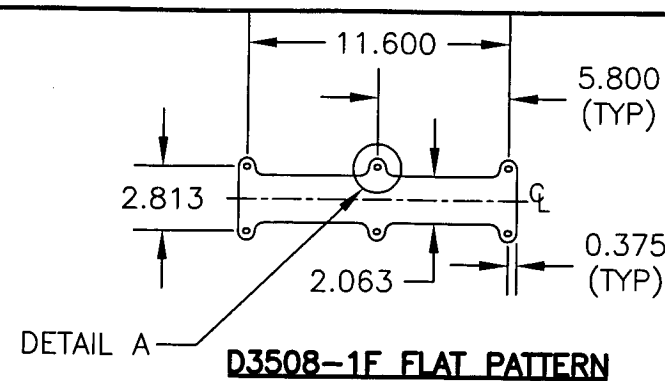
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27713

**PRELIMINARY ISSUE**

**D3508-1/-3/-5/-7 WEARPLATE NOTES**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

A		06.04.21		NEW ISSUE	
DESIGN		DRAWN BY		 DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH		- PH			
CHECKED		APPROVED		DRAWING NO.	
				D3508	
DATE				TITLE	
06.04.21				WEARPLATE	

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REV. A


SHEET 1 OF 1

SCALE

1:



m100473

 <b>SIDERURGICA DEL ORINOCO S.A.</b> MATANZAS - VENEZUELA		<b>CERTIFICADO DE CALIDAD / MILL TEST CERTIFICATE</b>		PAGINA: 01-A Nº DE CERTIFICADO: 04210437 ID: 28925	
		D MONTREAL, CANADA EN SI TP I NT OO		OCOMPRA - Purchase Ord. Nº * OVENTA - RN - Bidor Ord. Nº SA98616 -07 DESPACHO - Shipper Nº FACTURA - Invoice Nº VEHICULO - Vehicle IDA	
CS U L T E O TECHINTRADE CORP. 2200 WEST LOOP SOUTH, SUITE 750 HOUSTON, TEXAS 77027.		D MONTREAL, CANADA EN SI TP I NT OO		OCOMPRA - Purchase Ord. Nº * OVENTA - RN - Bidor Ord. Nº SA98616 -07 DESPACHO - Shipper Nº FACTURA - Invoice Nº VEHICULO - Vehicle IDA	
PRODUCTO Product PRIME NEWLY PRODUCED COLD SAMUEL. SON & CO J15000 /		ROLLED STEEL COILS TECHINTRADE S.O. 100000217		ASTM A 1008 CS TIPO-B	
DIMENSIONES Dimensions COLOUR MARK SIZE 0.0530 " MIN X 48.000 "		TIPO DE ANALISIS Analysis Type HEAT PHYSICAL TEST			

PHYSICAL TEST				CHEMICAL COMPOSITION - %															
Nº COLADA Heat Nº	Nº DE MUESTRA Sample Identification	TRACCION			DRZ	DOB	C	MN	P	S	SI	CU	AL	MO	NB	V	NI	CR	B
		ESF Y.P	ESF UTS	% AL	-1	-2	-2	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-4
		MPA	MPA	002P	HRB	GRAD													
		MIN.	MAX.																
		1.00	2.00	1.00		2							20						
					600	15	60	30	35	100	200	80	60	8	8	200	150	10	
243097		214.00	312.00	40.00	490	OK	005	028	010	004	023	010	029	004	001	001	011	013	000
544031		215.00	336.00	38.00	500	OK	006	028	009	004	064	002	029	002	001	001	003	006	001
644146		187.00	274.00	38.00	580	OK	007	033	009	001	032	007	025	002	001	001	005	009	000

C4374B

OBSERVACIONES / NOTE

**SIDERURGICA DEL ORINOCO S.A.**  
 Gerencia de Gestión de Ordenes  
 as issuing agent